

SPUT

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|---|--|---------------------|-----------|
| DART AEROSPACE LTD | | Work Order: | 22251 B |
| Description: Pin Assembly | | Part Number: | D3332-041 |
| Dwg: D3332 Rev. A PAGE 1,3,4 | | Qty: | 9 |
| | | Page 1 of 1 | |

| Step | Location | Procedure | By | Date | Qty | | | | | | | | | | | | |
|------|--------------------|--|--------------|-------------|-------------|-------|---|---------|--------|--------------|-----|-----|-----------|--------------|-----|----------|---|
| 1 | DC | Issue Traveler | HA | 05.01.17 | 10 | | | | | | | | | | | | |
| 2 | MC | Machine D3332-3 as per Folio FA493 and Dwg D3332 Material: AISI 1018-1025 Ø0.500" Round Bar (M1018-R0.500) Identify for D3332-3 Batch: <u>M16210</u> | ml | 05/02/17 | 10 | | | | | | | | | | | | |
| 3 | QC2 | Inspect parts as they come off the CNC machine Identify as D3332-3 | ml | 05/02/17 | 10 | | | | | | | | | | | | |
| 4 | QC8 | Second check | EL | 05.02.02 | 10 | | | | | | | | | | | | |
| 5 | MFA <i>Canl</i> | Fabricate D3332-5 as per Dwg D3332 Material: AISI 1018-1025 Ø0.313" Round Bar (M1018-R0.313) Identify as D3332-5 Batch: <u>M16634</u> | CPL | 05-02-02 | 10 | | | | | | | | | | | | |
| 6 | MFA <i>Canl</i> | Assemble and Weld using D3332-041T1 as per Dwg D3332 Pick: <table><tr><th>Qty</th><th>Part Number</th><th>Description</th><th>Batch</th></tr><tr><td>1</td><td>D3332-1</td><td>Handle</td><td><u>22268</u></td></tr><tr><td>A/R</td><td>N/A</td><td>Steel Rod</td><td><u>M9326</u></td></tr></table> Identify as D3332-041 | Qty | Part Number | Description | Batch | 1 | D3332-1 | Handle | <u>22268</u> | A/R | N/A | Steel Rod | <u>M9326</u> | CPL | 05-02-15 | 2 |
| Qty | Part Number | Description | Batch | | | | | | | | | | | | | | |
| 1 | D3332-1 | Handle | <u>22268</u> | | | | | | | | | | | | | | |
| A/R | N/A | Steel Rod | <u>M9326</u> | | | | | | | | | | | | | | |
| 7 | QC5 | Inspect work to Step 6 | ml | 05 02 15 | 9 | | | | | | | | | | | | |
| 8 | FP | Powder Coat Fire Red (Ref: 4.3.5.10) as per QSI 005 4.3 Cover D3332-3 and cover thread only for D3332-5 prior to painting | ml | 05 02 17 | 9 | | | | | | | | | | | | |
| 9 | QC3 | Inspect Powder Coat | UL | 05.02.18 | 9 | | | | | | | | | | | | |
| 10 | ST | Identify and Stock | UL | 05.07.18 | 9 | | | | | | | | | | | | |
| 11 | AC | Cost / part: <u>29.87</u> | Sys | 05-02-21 | 9 | | | | | | | | | | | | |
| 12 | DC | Close W/O <u>29.87</u> Inspect Level 21 | HA | 05.02.23 | 9 | | | | | | | | | | | | |

| Rev | Date | Change | Revised By | Approved |
|-----|----------|-----------|------------|--------------------|
| A | 05.01.13 | New issue | KJ/JLM | <i>[Signature]</i> |

RELEASED

05/01/17

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|---------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Mfg / Design Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|----------------------------------|----------------|---------------------------|------------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Design Mgr | Approval QC Inspector |
| | | | Initial Design Mgr | Action Description Design Mgr | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
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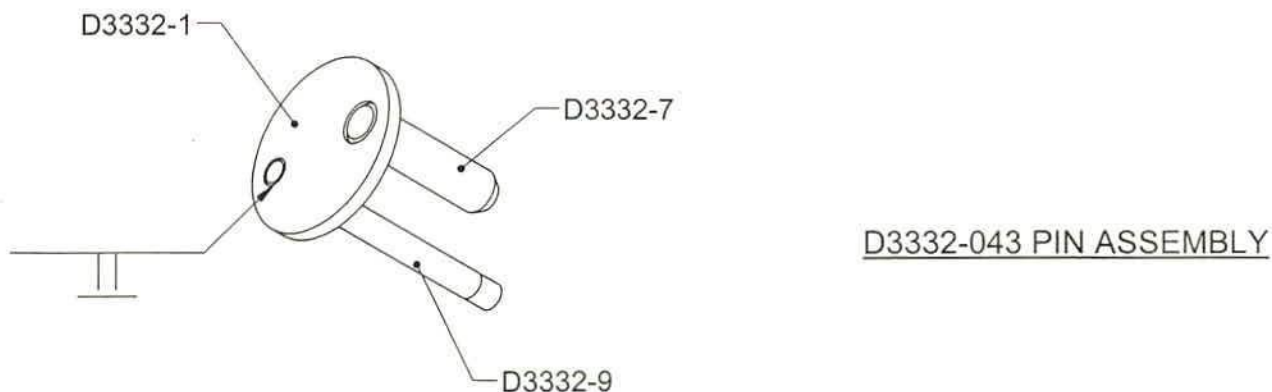
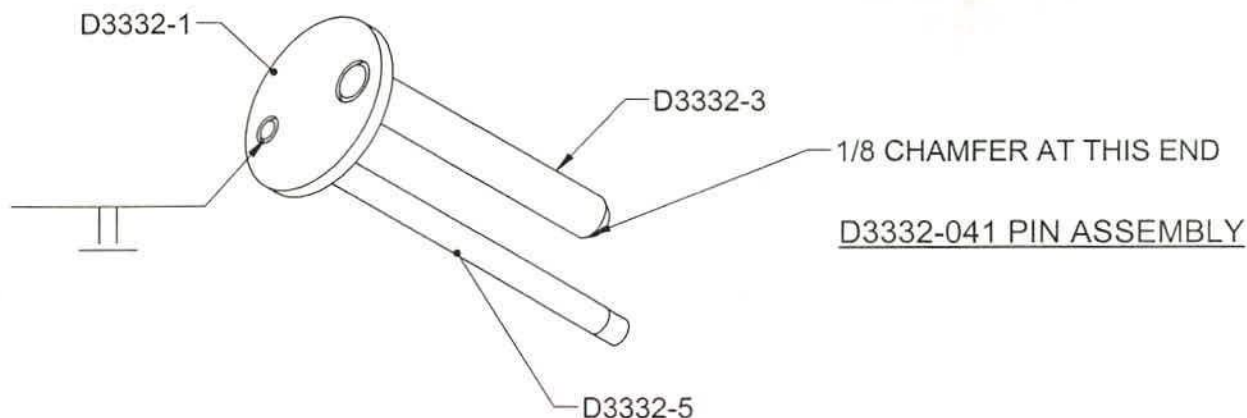
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

NOTE: Date & initial all entries

QA: N/C Closed: _____ Date: _____



| | | | |
|------------------------------|--------------------------------|---|------------------------|
| DESIGN <i>[Signature]</i> | DRAWN BY <i>[Signature]</i> | DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA | |
| CHECKED <i>RT</i> | APPROVED | DRAWING NO. D3332 | REV. A SHEET 1 OF 4 |
| DATE 04.12.14 | TITLE PIN ASSEMBLY | | SCALE 1:2 |
| A | 04.12.14 | NEW ISSUE | |



NOTES:

- 1) POSITION PARTS USING D3332-041T1
- 2) WELD PER DART QSI 004
- 3) FINISH: POWDER COAT FIRE RED (REF. 4.3.5.10) PER QSI 005 4.3
(COVER THREAD ONLY FOR D3332-5/-9 PRIOR PAINTING)
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 5) ALL DIMENSIONS ARE IN INCHES
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.10

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NO. 22251

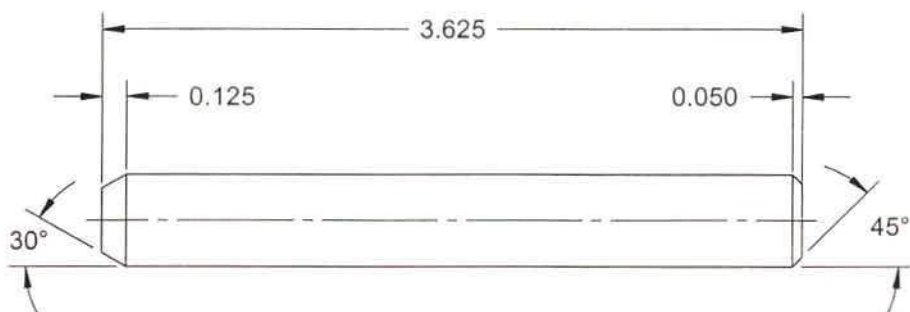
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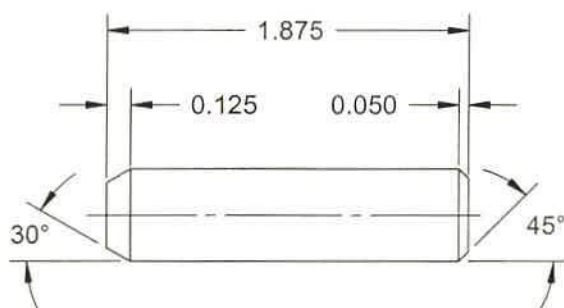
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| DATE 04.12.14 | | TITLE PIN ASSEMBLY | SCALE 1:1 |



3332-3 PIN



3332-7 PIN

NOTES:

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097
(REF. DART SPEC. M1018R0.500)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) BREAK ALL SHARP EDGES 0.005 TO 0.010

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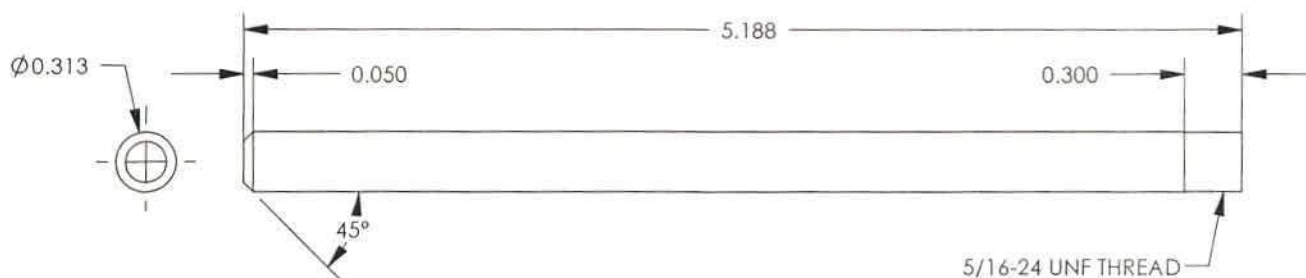
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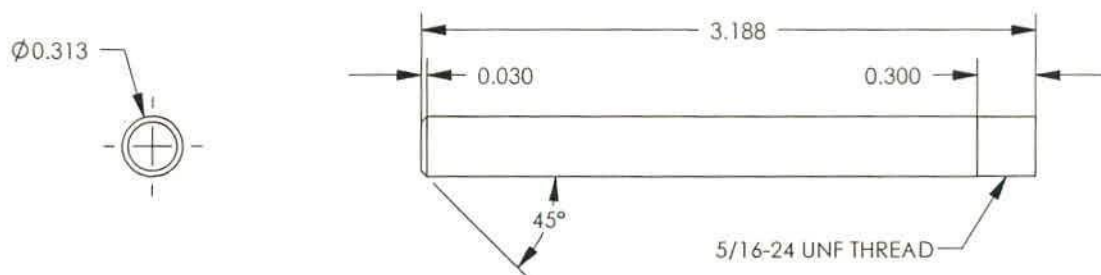
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| DATE 04.12.14 | | TITLE PIN ASSEMBLY | SCALE 1:1 |



D3332-5 SHAFT



D3332-9 SHAFT

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WORK ORDER
NO. 22251

NOTES:

- 1) MATERIAL: 1018-1025 ROUND BAR STEEL PER MIL-S-7097
(REF. DART SPEC. M1018-R0.313)
- 2) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 3) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 4) ALL DIMENSIONS ARE IN INCHES

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Job Costing Report

Dart Aerospace Ltd.
Hawkesbury

Jan 17, 2005
01:31 pm

Work Order No : 0022251
Project Name : D3332-041
Project For :
Work Order Type : Main
Main WO Number :
House Part Number : D3332-041
Description : Pin Assembly
Manufactured : Yes
Amount Req'd : 10
Amount Done : 0
Start Date : 01-17-05
Est Finish Date :
Act Finish Date :
Drawings Req'd : No
Ok for Approval :
Approval Rec'd :

Department Code:
Burden Flags : NNNNNNN
WO Status : Open
Invoice State : Not Invoiced
Invoice Date :
Invoice Number :
Invoice Amount : 0.00

Order Entry No :
OE Value : 0.00

Est Margin : 0.000%
Actual Margin : 0.000%

\$0 Posted to Finished Goods

| | Estimated | Actual | Var. % | Posted | To Post |
|---------------------|-----------|--------|--------|--------|---------|
| Material Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Engineering Hours : | 0.00 | 0.00 | 0.00 | | |
| Engineering Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Production Hours : | 0.00 | 0.00 | 0.00 | | |
| Production Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Packaging Hours : | 0.00 | 0.00 | 0.00 | | |
| Packaging Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| OverHead Hours : | 0.00 | 0.00 | 0.00 | | |
| OverHead Cost : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| CNC Hours : | 0.00 | 0.00 | 0.00 | | |
| CNC : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Misc. Hours : | 0.00 | 0.00 | 0.00 | | |
| Misc. : | 0.00 | 0.00 | 0.00 | 0.00 | 0.00 |
| Burden : | 0.00 | 0.00 | 0.00 | | |
| Total Cost : | 0.00 | 0.00 | 0.00 | | |
| Margin : | 0.000 | 0.000 | | | |
| Selling Cost : | 0.00 | 0.00 | | | |

| | | |
|--------------------------|-----------|--------|
| | Estimated | Actual |
| Labour Hrs/Amount Done : | 0.00 | 0.00 |
| Profits/(Loss) : | 0.00 | 0.00 |